

MUST SHIP WED 29/11

Dart Aerospace Ltd.

Date: Thursday, 11/23/2006 1:09:43 PM
User: Kim Johnston

SHIP SOONER

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT LH (FOLDING)	
Job Number	: 29684		Part Number	: D2801041	
Estimate Number	: 11652		Drawing Number	: D2801 REV A 1 6P 06.11.23	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/23/2006 S.O. No. : N/A		Drawing Revision	: A 1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/29/2006 Qty: 2 Um: Each	
Previous Run	: N/A				
Written By	:				
Checked & Approved By	:				
Comment	: Est B01.04.26 Changed D2802-041 to -1 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion 32825		<i>PE 06.11.23</i>
	Check Material for any Dents or Defects		<i>PE 06.11.23</i>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE,1	
	Comment: LARGE FABRICATION RESOURCE 1		
	1-Cut D2622 extrusion to 86.15" long as per Dwg D2801		<i>PE. 06.11.23</i>
	2-Deburr and bevel ends for welding		<i>PE. 06.11.23</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP		<i>11/06/11/23 2</i>
4.0	D2734	206 Step Endplate	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap 32821		<i>PE 06.11.23</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D28021 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2802-1	Arm	325708

PL 06.11.23 ②

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms as per Dwg D2801

Weld end caps as per Dwg D2801

Inspect for foreign object per QSI 024

Grind end cap welds flush

PL 06.11.24
PL 06.11.24
PL 06.11.24
PL 06.11.24

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 06.11.25 ②

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL 06.11.25 ②

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PL 06.11.27 ②

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PL 06.11.28 ②

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 06.11.27
FC 06 11 28Q

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/11/28	11.1	- Weld last end cap as per dwg A2801 - grind weld flush	LL	06/11/28	2		BB 06/11/28
06/11/28	11.2	QC S QC G	LL	06/11/28	2		BB 06/11/28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29684

Part Number: D2801041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Wing Walk per Dwg D2801 and QSI 005 4.4

M102635

26.06.11/29 (28)

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FC 06 11 29 (2)

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev A1

43.06/11/29 (2)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/11/29 (2)

Job Completion



26.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

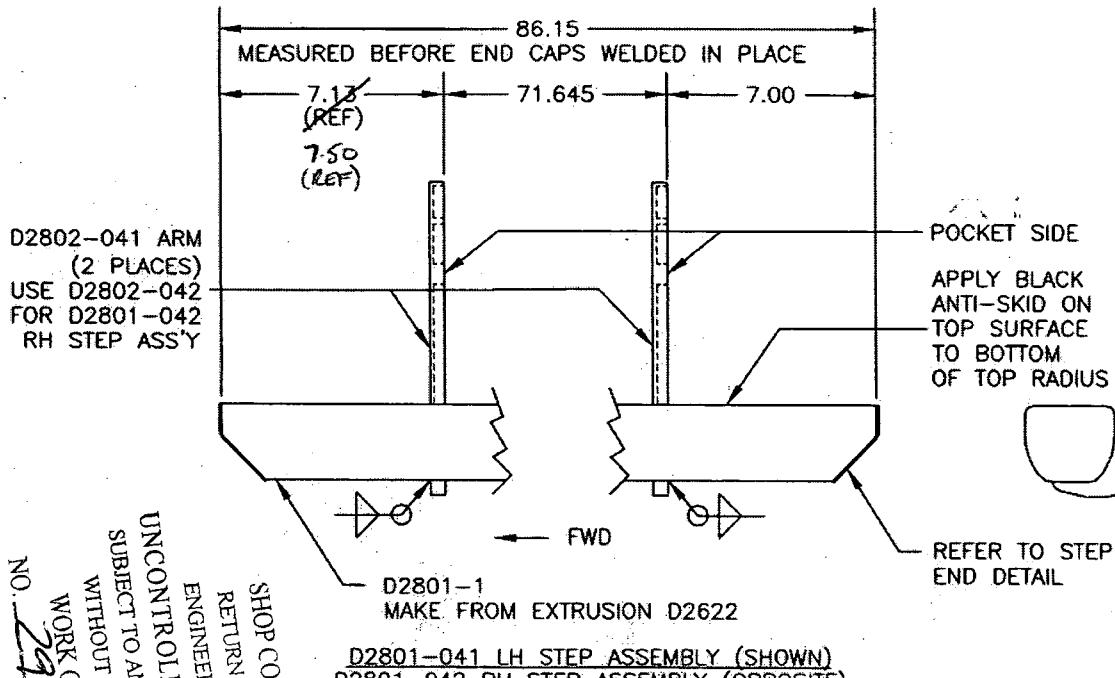
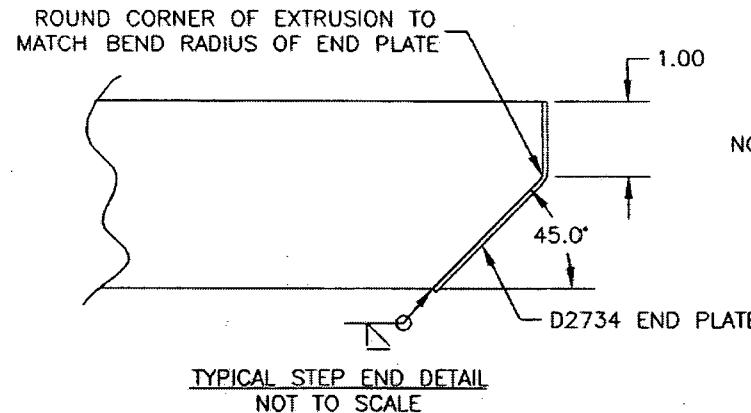
DARTCOPY
SUSPENDED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. A
SHEET 1 OF 1

DESIGN	DRAWN BY	APPROVED	DRAWING NO.	SCALE
00.11.03	A	00.11.03	NEW ISSUE	NIS
A1	CP	CP	03.06.16 D2801	7.50 WKS 7-13
DATE	TITLE	STEP WELDMENT		

RELEASED
00.11.13

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29684